



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18608
Job Sheet 199120



Part No: RBT18608

Job Qty: 1 pcs

Part Name: Main Rotor Control Rigging Aid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 10/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 18666

Note: DWG RBT18608 Rev 2A IPP Rev. A 19.08.09 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	10/11/19	10/11/19	0.00	0.39	Small Fab - 1		WLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	10/11/19	10/11/19	0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/11/19	10/11/19	0.00	0.00	Packaging 3 - 1 - B4B		Plex 8/13/19 9:26 AM Dart.lajeunesse.marie
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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CANADA
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Email: sales@dartaero.com
www.dartaero.com

Container No: S225849



Part: RBT18608

Job No: 199120

Serial No/Batch: S225849

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 10/24/19

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

140 QC 21 - FG

1 pcs

10/22/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

DAS

21

8-53

OCT 2 5 2019

Part Op 100 - (Small Fab) 1-Assemble as per drawing. 2-Fill engraving with white paint as per drawing.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

GA-TBD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS35206-215	Screw	2 Ea (2 ea)	100-Small Fab - 1	F112557
MS35649-242	CAD Plated Hex Nut, 4-40 Course Thread	2 Ea (2 ea)	100-Small Fab - 1	5225302
RBT18608-2	Weldment	1 pcs (1 ea)	100-Small Fab - 1	5219414
RBT18608-5	Gauge	1 pcs (1 ea)	100-Small Fab - 1	5218764

Job Allocations

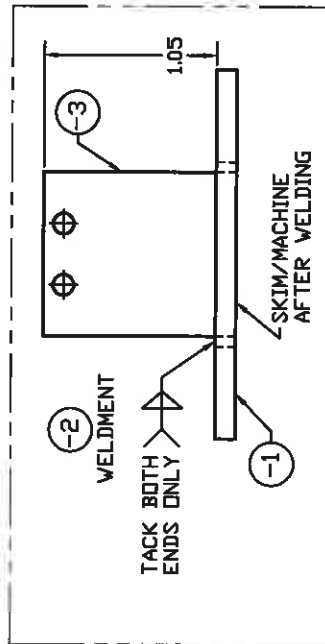
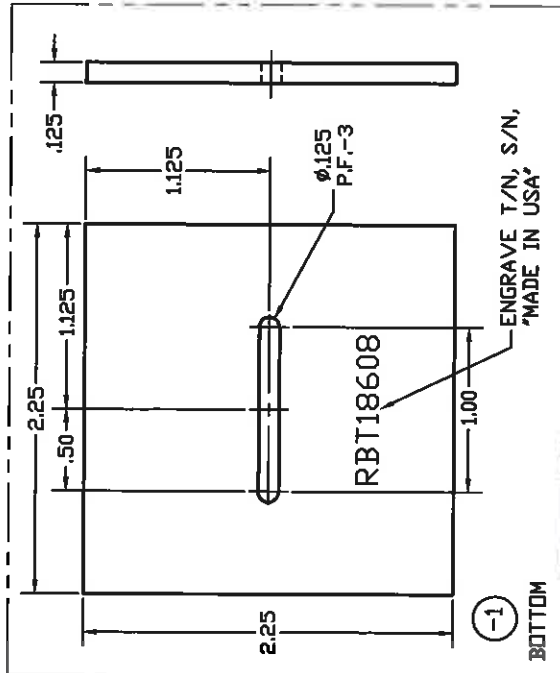
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	MS35206-215	2	102	0
	MS35649-242	2	0	0
	RBT18608-2	1	10	0
	RBT18608-5	1	4	0

Part Specifications

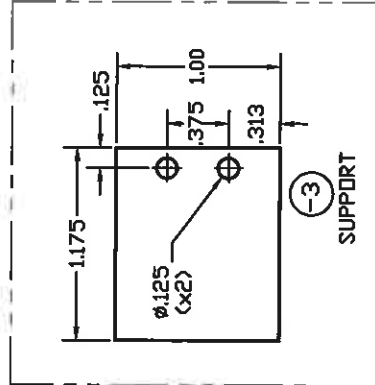
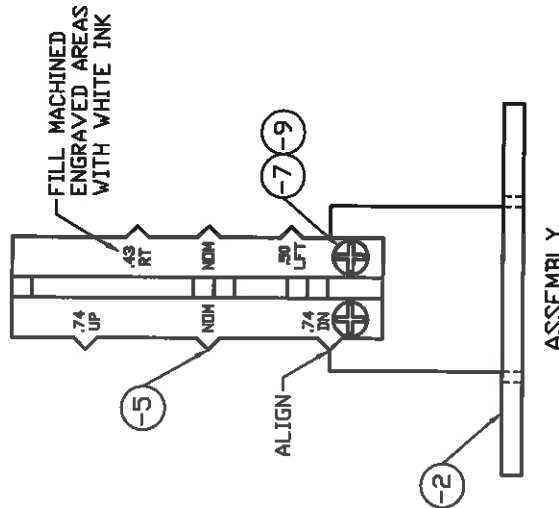
Specifications could not be found.

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SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199120 MC5
19-08-13



REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	IMPLEMENTED NEW FORMAT, AND ADDED ASSEMBLY DRAWING. CHANGED -1 SLOT SIZE FROM 1 IN. LENGTH TO 1.125. ALSO ADDED CLEAN BOTTOM SURFACE NOTE TO WELDMENT.	3/4/09	WP	G.E.
1A	CH'D ENGRAVE NOTE P/N -1, ADDED FILL MACHINED ENGRAVE NOTE ON ASSY. VIEW.	7/17/09	RJC	RW
2	DIMENSIONAL CHANGES PER MD HELICOPTERS MAINT. MANUAL -3 WAS .425 LONG NOW 1.175. -5 DIMENSIONAL CHANGES. WAS .48 NOW .45, WAS .28 NOW .32, WAS .78 NOW .75, WAS .53 LFT NOW .50 LFT, WAS .27 NOW .30, WAS 1.22 FWD NOW 1.190 FWD. MATERIAL CALLED FOR IN MD MANUAL IS 2024-T4, WILL STAY WITH PREVIOUSLY MADE MATERIAL 6061.	3/4/09	WP	RW
2A	ANNOTATED -7 & -8 ARE BUYOUTS IN BOM PER R.W.	2/23/11	RAC	

ASSY	B/D	PART #	QTY	UNIT	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS	Pg.
1	-1	BOTTOM	1			6061 FLAT BAR	1/8 x 2-3/8 x 2-3/8	1
	-2	WELDMENT	1				-1 & -3	1
1	-3	SUPPORT	1			6061 FLAT BAR	1/8 x 1 x 1-1/4	1
	-5	GUAGE	1			6061 T BAR	3/4 x 3/4 x 2-3/8	2
B/D	-7	ROUND HEAD MACH. SCREW	2			PLATED STEEL	#4-40 x 3/8	1
B/D	-9	NUT	2			PLATED STEEL	#4-40	N/S

TITLE		M/R CONTROL RIGGING AID		REV	2A
DWG NO.		RBT18608		DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES ON DECIMALS		APPROVED: <i>[Signature]</i>	
FRACTIONS ± 1/32		ANGLES ± .5°		HEAT TREAT: RED ANODIZE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x .45 PR .015 R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL: MD 369D/E/FF - 500N	
SCALE	NTS	DATE	7-01-05	SHEET	1 of 2

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	DEPARTMENT/PROCESS	Date: _____ Sequence #: _____ Description Work Order Deviation QTY Affected: _____ Disposition	MRB (QS1042) Completed By Lead hand / Supervisor QC / QA Coordinator																																																							
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th style="width:25%;">Root Cause</th> <th colspan="12">FAULT CATEGORY</th> </tr> <tr> <td rowspan="6"> Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ </td> <td>Pressure/Forced ☐</td> <td>Contamination ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Misaligned/off center ☐</td> <td>Folio/Program ☐</td> <td>Outside Tolerance ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>BOM/Route ☐</td> <td>Grain Direction ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist ☐</td> <td>Incomplete/Unclear Instructions ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Out of Sequence ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Fit/Function ☐</td> <td>Off-set/Set-up ☐</td> <td></td> </tr> <tr> <td colspan="13">Other/Details:</td> </tr> </table>					Root Cause	FAULT CATEGORY												Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		Other/Details:												
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